

# FREIOPLAST

## Hydro-Dip-Coating WL1606

- Water-thinnable Dip-Coating
- Good adhesion on steel
- Volatile organic compound is lower than 5 % per weight

<b>Technical / Physical Data</b>	<b>Resin/ binder</b>	Preparation based on watery acrylate-styrene-copolymer-dispersion
	<b>Colour</b>	acc. to RAL 840 HR other colour shades on request
	<b>Gloss value</b> visuell	mat
	<b>Original viscosity</b> DIN 53211*	35 to 45 sec. / 4 mm cup
	<b>Thinner</b>	demineralised water or tapwater degree of hardness < 15° "deutsche Härte"
	<b>pH-value</b>	9,5      + / - 0,2
	<b>Density</b> calculated	1,2 g / ml      + / - 0,1
	<b>Solid content</b> calculated	50 %      + / - 5
	<b>Solid content in volume</b> calculated	310 ml / kg      + / - 10
	<b>Consumption</b> calculated in original viscosity, without application loss	90 to 100 g / m <sup>2</sup> dry film thickness 30 µm see „Special remarks“
	<b>Spreading rate</b> calculated in original viscosity, without application loss	10 to 11 m <sup>2</sup> / kg dry film thickness 30 µm see „Special remarks“

### Storability

Approx. 9month in original packings at an ambient temperature of 15 to 25 °C, in case the original packings are tightly closed. Opened packing must be used very shortly. Protect against frost. The minimum storage stability of each batch is mentioned on the product label. A storage time beyond the mentioned date doesn't necessarily mean that the material is unusable. In this case a check of the qualities which are important for the respective.

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## Processing and application

### Application

Stir up before the use carefully (e.g. with high-speed mixer).

dipping: after viscosity adjustment to 17 to 20 sec.  
spraying: in original viscosity

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### Substrates

steel

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### Pretreatment

The substrate must be free of materials which prevent adhesion, e.g. oil, grease, dust and surfactant. According to the requirements we recommend to apply the suited chemical (e.g. phosphatizing, chromating) or / and mechanical (e.g. shot blasting) pretreatment.

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### Application temperature

above 10 °C

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### Drying

air drying at 20°C

dust dry:	after 30 min	(degree of drying 1/ DIN 53150)
dry to touch:	after 1 h	(degree of drying 4/ DIN 53150)
complete dry:	after 3 days	(swinging beam hardness/ ISO 1522)

oven drying: up to 80°C possible (object temperature)

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### Repair coating

After sanding with the same system.

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### Cleaning of working equipment

immediately after use: water, lightly dried material on the surface of working tools:  
organic cleaners, e.g. EFD-Thinner 400424

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### Advice for safety protection and protection of health

The usual precautionary measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning health protection and environment protection can be read in the corresponding safety data sheet.

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## Special remarks

### Test condition

\*Indication of the delivery viscosity according to DIN 53211:

DIN 53211 was withdrawn in October 1996.

On request the value is available according to DIN EN ISO 2431.

All information is based on a standard climate 20/65 DIN 50014.

For the calculation of the practical consumption loss additions have to be considered. Indications to this are the practical experience and advices given in DIN 53220.

All information are based on our product knowledge and experience. To the application we have no direct influence. For further information please don't hesitate to contact us.

The information mentioned herein are reference values and are not given as specification.